

Work Order ID 45678-3 - 2

September 30, 2009 7:27:49 AM



Page 1

Item ID: D3651-041
Revision ID: B
Item Name: Aft Base Assembly

Accept



Setup Start



Stop



Start Date: 9/30/09 Start Qty: 1.00

Required Date: 10/09/09 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:
QC:

[Signature]

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3651

Rev B

100



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

SB 09/09/29

110



Small Fab

Small Fab

Small Fab

0.00

Memo

0.00

1-Assemble as per dwg D3651 2- Seal all mating surfaces and gaps using
Proseal 700 fire wall sealant as per dwg D3651 Batch: M110624 3-install
D3651-1 using 3M high performance contact adhesive 1357 as per dwg
D3651 Batch: 105623

EB 09/09/29

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

27 09/10/12

GI

Date: Tuesday, 10/02/2009 1:08:58 PM
 User: Melanie Fauteux

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 45678 *★3*
 Estimate Number : 13043
 P.O. Number :
 This Issue : 10/02/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL / MED FAB
 Previous Run : 42040
 Written By :
 Checked & Approved By : *mf 09-02-10*
 Comment : Est Rev:A New Issue 07-09-27 DD verified by: EC
 Est Rev:B ECN 1113P 08-01-22 DD verified by: EC
 Est Rev:C ecn1162 08-04-02 DD verified by: EC

Drawing Name : AFT BASE ASSY
 Part Number : D3651041
 Drawing Number : D3651 REV.B
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 17/02/2009 Qty: *2* Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

2.0 ✓ D3651043 Flange Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 FLANGE ASSEMBLY *B42114*

FF 09/02/25 (4)

3.0 ✓ D36511 Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 GASKET *B44674*

FF 09/02/25 (4)

4.0 ✓ D36519 Inside Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 DOUBLER *B35077 45451*

FF 09/02/25 (4)

5.0 ✓ D365111 Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 GASKET *B45452*

FF 09/02/25 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/02/2009 1:08:58 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BASE ASS'Y

Job Number: 45678

Part Number: D3651041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0



D365113

Outside Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

DOUBLER

B 45453

FF 09/02/25 (4)

7.0



CR3523402

RIVET



Comment: Qty.: 58.0000 Each(s)/Unit Total: 232.0000 Each(s)

RIVET

M 110914

M 11127 (222)

FF 09/02/25 (4)

8.0



SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: 1-Assemble as per dwg D3651

2- Seal all mating surfaces and gaps using Proseal 700 fire wall sealant as per dwg D3651

Batch: M 110624

3-install D3651-1 using 3M high performance contact adhesive 1357 as per dwg D3651

Batch: M 105623

FF 09/02/26 (4)

9.0



QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0



PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: _____

11.0



QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

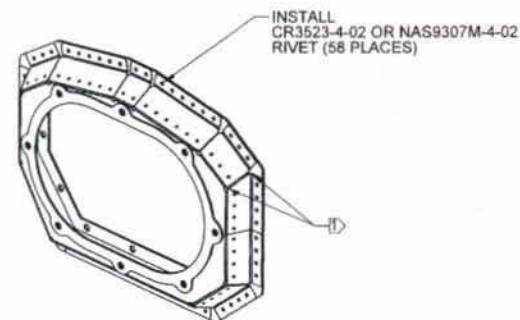
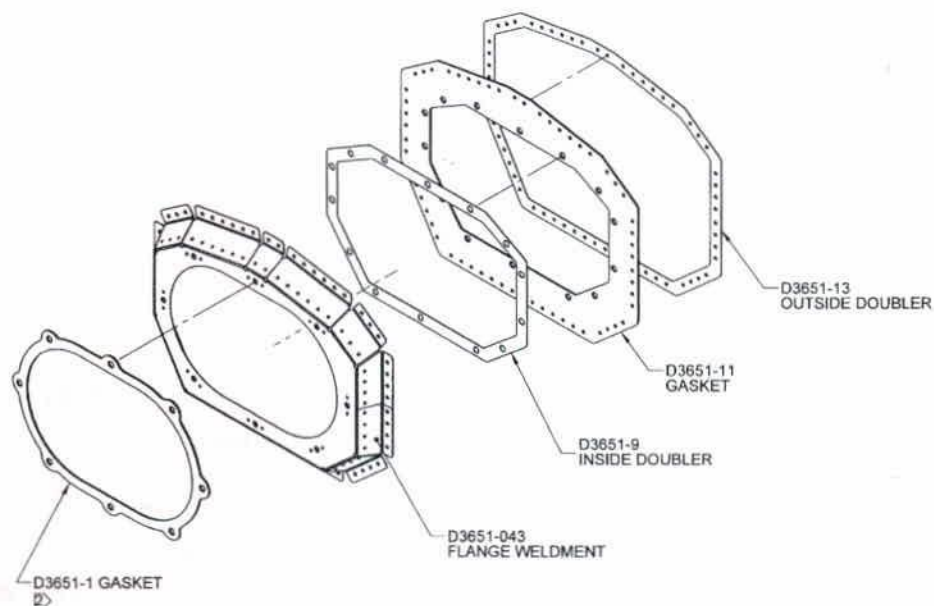
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
01/09/29	8	Inlet had to be removed and found to removed hole was damaged slightly over sized. RC: process / thin material.	02/10/29	Drill hole with weld per 05/004 & grind flush. - transfer drill & debris	CP 09-09-30	S 01/10/29	05/10/29	05-09-29

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3651-041	AFT BASE ASSEMBLY
1	D3651-043	FLANGE WELDMENT
1	D3651-1	GASKET
1	D3651-9	INSIDE DOUBLER
1	D3651-11	GASKET
1	D3651-13	OUTSIDE DOUBLER
58	CR3523-4-02 or NAS9307M-4-02	RIVET

D3651-041 AFT BASE ASSEMBLY

D3651-041 NOTES:

- 1) SEAL ALL MATING SURFACES AND GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) INSTALL D3651-1 USING 3M HIGH PERFORMANCE CONTACT ADHESIVE 1357
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.6 lbs

45678
REFERENCE ONLY

B	SHEET 1: GENERAL UPDATE SHEET 2: 8.74 WAS 8.50, 0.88 WAS 0.98, REMOVED ANGLE SHEETS 4, 5, 6, 8 & 9: GENERAL DIMENSIONAL UPDATE SHEET 7: 5.514 WAS 5.504	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO	REV. B
MFG. APPR.	RF	D3651	SHEET 1 OF 9
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	AFT BASE ASSEMBLY	1:4
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

i,634 60 zwif

Work Order ID 45678

June 26, 2009 11:39:11 AM



Page 1

Item ID: D3451-041

Revision ID: A

Item Name: Handle and Lock-Down Assembly

Start Date: 15/07/2009 Start Qty: 4.00

Required Date: 03/08/2009 Req'd Qty: 4.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan: MF

Date: 09/09/24

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3451

Rev A

100



Large Fab

Large Fab

0.00

Memo

0.00

Large Fab

Weld as per dwg PB67-43001

110



QC

Quality Control

QC9- Inspect visual per QS1004- Fusion Welds

0.00

Memo

0.00

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

small

Work Order ID 45678

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Page 2

Item ID: D3451-041
Revision ID: A
Item Name: Handle and Lock-Down Assembly
Start Date: 15/07/2009 Start Qty: 4.00
Required Date: 03/08/2009 Req'd Qty: 4.00
Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
140 Powdercoat Powder Coating	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3 Memo START TIME: _____ FINISH TIME: _____ OVEN TEMPERATURE: _____	0.00 0.00							
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							

Work Order ID 45678

June 26, 2009 11:39:11 AM



Page 3

Item ID: D3451-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Handle and Lock-Down Assembly

Start Date: 15/07/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- assemble rubber handle as per dwg PB67-43001

170

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

180

0.00



Packaging

Identify as per dwg & Stock Location: _____

Memo

0.00

Packaging

Work Order ID 45678

June 26, 2009 11:39:11 AM



Page 4

Item ID: D3451-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Handle and Lock-Down Assembly

Start Date: 15/07/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Picklist Print

June 26, 2009 11:27:46 AM

Page 1

Work Order ID: 45678

Parent Item: D3451-041RevA

Parent Item Name: Handle and Lock-Down Assembly

Start Date: 15/07/2009

Required Date: 03/08/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

[illegible]